

CLAIMS

1. A method of assembling a car body, the method comprising the steps of: locating a lower end of a vertical side member
5 relative to an end of an underbody held in a predetermined position of a car body assembling line; locating the side member to the underbody at not less than two portions of the lower end; and temporarily welding, in such a locating state, the side body to the underbody;

10 the car body assembly line being provided, in a vicinity thereof, with a slide base which is movable toward and away from the assembly line,

the car body being provided, in a vicinity thereof, with a locator which is removably placed on the slide base for
15 locating the side member,

the car body assembly line being provided, in a vicinity thereof, with a lifter for placing the locator on the slide base when the slide base is away from the assembly line,

the locator being placed onto the lifter when the lifter
20 is at an upper limit, the locator being placed onto the slide base when the lifter is lowered,

the side member being supported by the locator, and the slide base being moved toward the car body assembly line for locating the side member relative to the underbody.

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2. The method according to claim 1, wherein the lifter is lifted up for detaching the locator from the slide base, and wherein when the lifter is at the upper limit, the locator is removed

from the lifter, while another locator is placed onto the lifter, then the lifter being lowered for placing said another locator onto the slide base.

5 3. The method according to claim 1, wherein the locator is smaller than the side member, as viewed in a vertical direction and in a direction parallel to a transfer direction of the assembly line.

10 4. The method according to claim 1, wherein the slide base is provided with a plurality of upwardly protruding locating pins, the locator being formed with a plurality of insertion holes corresponding to the locating pins.

15 5. The method according to claim 1, wherein the locator includes a bottom surface provided with a plurality of wheels for facilitating positional shift of the locator.

20 6. The method according to claim 5, wherein the lifter includes two supporting plates spaced from each other, the locator being placed on the supporting plates via the wheels.

25 7. The method according to claim 6, wherein the two supporting plates are spaced from each other at a distance great enough to allow insertion of the slide base therebetween.

8. The method according to claim 6, wherein each of the supporting plates of the lifter is provided with a locating

member for engaging with the wheel.

9. The method according to claim 1, wherein the side member
is located relative to the underbody by being supported by
5 the locator and an additional locator.

10. The method according to claim 9, wherein the two locators
are connected to each other via a connecting rod and moved
synchronously by the connecting rod.